



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G00232-3G-PO

Job Sheet 191253



Part No: RBW6305G00232-3G-PO **Job Qty:** 2 pcs

Part Name: Gimbal Torque Tube Bushing Installer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 4/29/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6305G00232-3G Rev 2 IPP Rev A 18.11.26 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	2 pcs	4/29/19	4/29/19	0.00	0.00	Purchasing - 1		APR 01 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	2 pcs	4/29/19	4/29/19	0.00	0.00	Packaging 2 - 1 - B4B		APR 01 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Container No: S168085



Part: RBW6305G00232-3G

Job No: 191253

Serial No/Batch: S168085

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/01/19

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	2 pcs	4/29/19	0.00 0.00	QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	DAS APR 01 2019 68 9-89
130	Packaging 3-1 - Stock - B4B	2 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	2 pcs	4/29/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
					QC 21 - SA - 70	APR 01 2019
Part Op 100 - Issue P/O to ARROW TECH MACHINE WORKS ; P/O _____ -Manufacture RBW6305G00232-3G as Descriptions: per DWG. -Certificate of Conformity is required 110 - Certificate of Conformity is required						

PO Details

Arrow Tech Machine Works (arr002-vu)



PO No: PO042703

Line No: 3

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6305G00232-3GP	Gimbal Torque Tube Bushing Installer	2 Ea (1 ea)	100-Purchasing	5/68084

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6305G00232-3GP	2	0	0

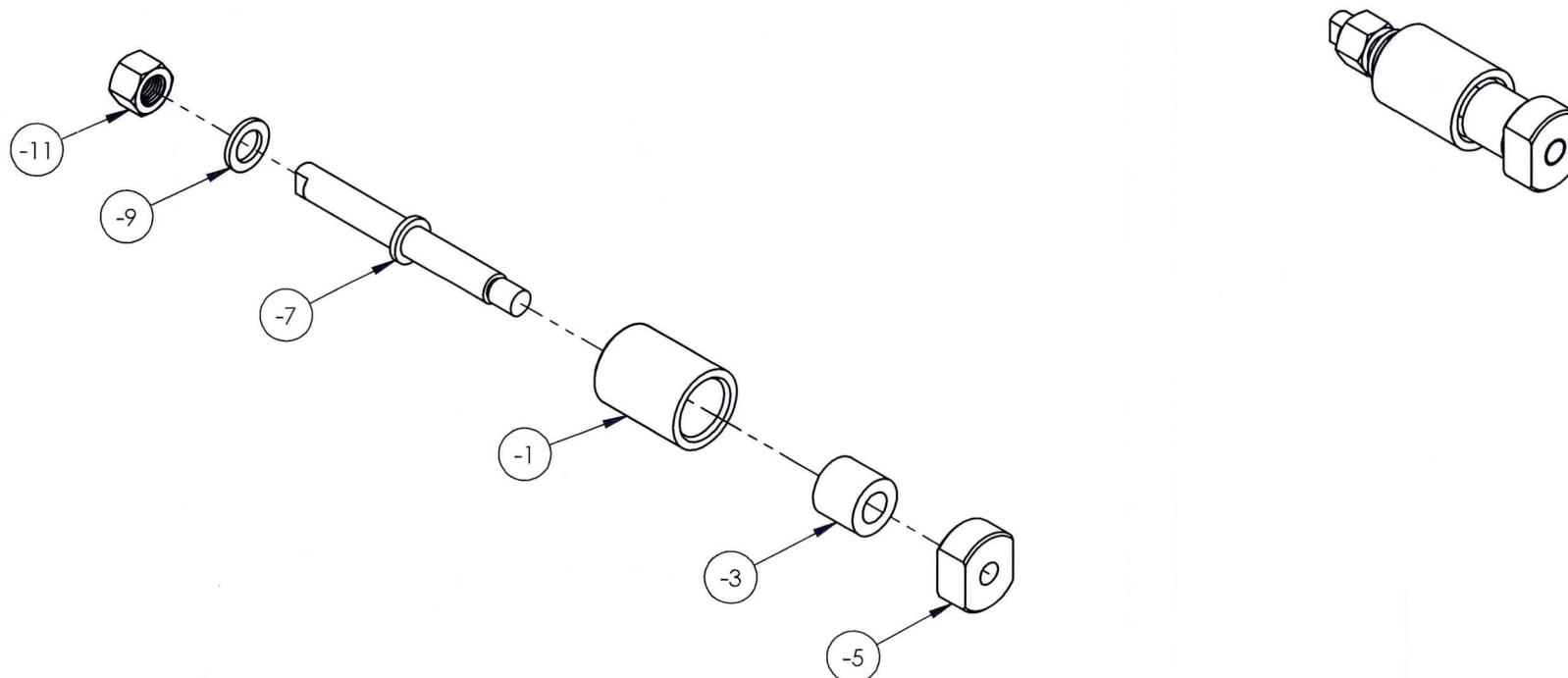
Part Specifications

Specifications could not be found.

Plex 4/1/19 8:57 AM Dart.Hadley.Shannon

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		BROKE OUT INTO INDIVIDUAL TOOL FROM KIT RBW6305G00132-3G.	4/7/2011	RJC	
1		-3 CH'D I.D. ADDED TOLERANCE WAS $\varnothing.379$ IS $\varnothing.375 \pm .005$ - .000. -7 CH'D O.D. ADDED TOLERANCE WAS $\varnothing.375$ IS $\varnothing.370 \pm .000$ - .005.	5/3/2013	CFS	GE
2	15-0292	-1, -3, -5 CH'D MATERIAL CALL OUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. -7 CH'D MATERIAL CALL OUT WAS 4140 Q&T IS 4140 Q&T / 4142 Q&T. CH'D DIM WAS $\varnothing.317$ IS $\varnothing.315$, WAS .030 IS .05 WAS .040 IS .04.	9/10/2015	RJC	JAG



NOTE:
ALSO SOLD WITH KIT RBW6305G00132-3G.

DART AEROSPACE	
TITLE GIMBAL TORQUE TUBE BUSHING INSTALLER	
DWG NO. RBW6305G00232-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 .XX $\pm$.01 .X $\pm$.1 FRACTIONS $\pm$ 1/8 ANGLES $\pm$ 5°	DRAWN BY: PERRITT APPROVED: <i>D. Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL AGUSTA
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 4/7/2011
SHEET 1 OF 5	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BASE	4140 Q&T / 4142 Q&T		2
			-3	1	GUIDE	4140 Q&T / 4142 Q&T		3
			-5	1	STOP	4140 Q&T / 4142 Q&T		4
			-7	1	STUD	4140 Q&T / 4142 Q&T		5
		B/O	-9	1	WASHER	STEEL	$\varnothing.3/8$ I.D. AN960-616L	1
		B/O	-11	1	HEX NUT	STEEL	3/8-24 UNF AN315-6	1



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Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042703



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO042703
PO Date: 2/25/19
Due Date: 4/29/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191247	RBW6305G01232-3GP			Gimbal Torque Tube Bushing Remover REV 3	Firmed	-	4/29/19	2 Ea	0 Ea	2 Ea	\$708.34/Ea	\$1,416.68
2	191252	RBW6205G13231-3GP			Arm Assembly As Per Dwg RBW6205G13231-3G Rev. 1	Firmed	-	4/29/19	9 Ea	0 Ea	9 Ea	\$298.00/Ea	\$2,682.00
3	191253	RBW6305G00232-3GP			Gimbal Torque Tube Bushing Installer REV 2	Firmed	-	4/29/19	2 Ea	0 Ea	2 Ea	\$708.75/Ea	\$1,417.50
4	191255	RBW6205G06131-3GP			Main Rotor Pitch Control Lever Expander REV D	Firmed	-	4/29/19	4 pcs	0 pcs	4 pcs	\$913.63/pcs	\$3,654.52
5	191258	RBW6205G03731-3GP			Trim Tab Bending Gauge Assembly REV 4	Firmed	-	4/29/19	3 Ea	0 Ea	3 Ea	\$1,204.00/Ea	\$3,612.00

Grand Total: \$12,782.70

940.75

232

464



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PURCHASE ORDER

PO042703



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

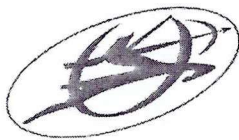
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "P. Lussier".

Plex 2/25/19 2:20 PM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 491

Date: 3/28/2019
PO Ref: 042703
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
9 ✓	ARM ASSEMBLY	✓ RBW6205G13231-3G
4 ✓	M/R PITCH CONTROL LEVER EXPANDER	✓ RBW6205G06131-3G
2 ✓	GIMBAL TORQUE TUBE BUSHING INSTALLER	✓ RBW6305G00232-3G
2 ✓	GIMBAL TORQUE TUBE BUSHING REMOVER	✓ RBW6305G01232-3G

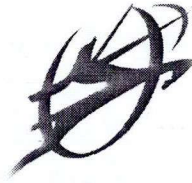
DAS
68
9-89

Received by: _____

Packaged by: J.M.L

Checked by: AdP

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: 042703 ✓ Dated: 3/28/2019

Our Order / Job No: 042703-3AWT Order Qty: 2 ✓

Part Name: GIMBAL TORQUE TUBE BUSHING INSTALLER

Part Number: RBW6305G00232-3G ✓

Lot Size: N/A Ship Date: 3/28/2019

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6305G00232-3G Rev: 2

Material Size and Type: -1,-3,-5,-7/4140 Q&T STEEL

Material Specifications: STEEL: ASTM A108, ASTM A29

Heat Treatment: (HRC 28-32)

Plating/Finish: ZINC PLATE: ASTM B633 TYPE 1 CLASS 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 03/28/19

Signed: 

DAS
68
9-89

PHGE Machine Works LLC dba Arrow Tech Machine Works
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